



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D5623-042
Job Sheet 183501

Accounting Job RD17-1048-01



2018-10-26-01

Part No: D5623-042

Job Qty: 1 ea

Part Name: Fwd Skidtube Protector, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 9/24/18

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: DWG D5623 REV:A IPP REV A 18.05.22 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/24/18	9/24/18	0.00	0.00	Start Up Waterjet		SC 18/09/19
110	Waterjet	1 pcs	9/24/18	9/24/18	0.00	0.06	Waterjet1		SC 18/09/19
120	QC	1 pcs	9/24/18	9/24/18	0.00	0.00	QC2 Waterjet-2		SC 18/09/19
130	QC	1 pcs	9/24/18	9/24/18	0.00	0.00	QC8-2		SEP 21 2018 68
140	Brake NC	1 pcs	9/24/18	9/24/18	0.12	0.01	Brake NC 1		SEP 21 2018 68
150	QC	1 pcs	9/24/18	9/24/18	0.00	0.00	QC5		SEP 25 2018 68
160	Large Fab	1 pcs	9/24/18	9/24/18	0.00	0.25	Large Fab 1		OCT 18/09/26 9-89
170	QC	1 pcs	9/24/18	9/24/18	0.00	0.00	QC9		68
180	QC	1 pcs	9/24/18	9/24/18	0.00	0.00	QC5		68
190	HandFinish	1 pcs	9/24/18	9/24/18	0.00	0.03	HandFinish4		SA 18-09-228
200	QC	1 pcs	9/24/18	9/24/18	0.00	0.00	QC3		OCT 01 2018 68
210	Packaging	1 pcs	9/24/18	9/24/18	0.00	0.00	Packaging3-1		OCT 01 2018 68
220	QC21-SA	1 Ea	9/24/18	9/24/18	0.00	0.00	QC21		OCT 01 2018 68

Part Op 110 - 1-Cut D5623-1F as per Dwg D5623 Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 160 - Weld as per dwg. -Index clamp as per dwg note 10
190 - APPLY TEXTURED COATING ON CONCAVE SURFACE ****AS PER NOTE 2 AND 3**** ON DWG AND QSI
BATCH: 138946 ***INDICATE FWD DIRECTION AS SHOWN PER NOTE 12 USING WHITE PAINT
MARKER***
210 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	1.2290 sf (1.229 ea)	90-Start up Operation	309402
MS21920-25	Clamp	2 Ea (2 ea)	160-Large Fab	5082848

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	1	291	0
160-Large Fab	MS21920-25	2	232	0

Part Specifications

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		OTY Effective _____		MRB (QSI042) Approval _____	
DART Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL: 513 632-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S112277 Part: D5623 - 042 Job No: 183501 Serial No/Batch: S112277 Revision: A Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/20/18						Disposition Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Environment _____ Design _____ Doc/Da _____ Equip/Tooling _____ Handling/Pr _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____		Poor Information _____ Rushing _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____		CUTS _____ Crushing _____ Heat Treat _____ Wave/Twist in Tube _____ Marks/Chatter _____		Inspection Incomplete/Unqualified _____ Contamination _____ Countersink _____ Cut Too Short _____ Instructions Incomplete/Unclear _____ Drill Holes _____	
				CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____							

Specifications could not be found.

Plex 9/19/18 8:30 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	183501
Description: FWD skid tube protector RH		Part Number:	125623-042
Inspection Dwg: 125623-042	Rev:	Page 1 of 1	

INSPECTION SHEET

[illegible]

Measured by:	<i>SE</i>	Checked by:		QC Inspector:	
Date:	<i>18/09/19</i>	Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	